



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

④

D119-796-241TRN
Job Sheet 169264-A



Part No: D119-796-241TRN

Job Qty: 1 ea

Part Name: Crosstube Turning Detail



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 12/5/17

Job Tracking No:

Due Date: 12/15/17

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV J IPP REV A RQ 14/05/27 VERIFIED BY DD IPP REV:B 16.05.04 AS PER DWG REV.I DD
VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	12/14/17	12/14/17	0.00	0.00	Start Up Crosstubes-1		PMP
100	Mori Seiki	1 pcs	12/14/17	12/14/17	1.77	1.72	Mori Seiki TL-40		PMP
110	QC	1 pcs	12/14/17	12/14/17	0.00	0.00	QC2-1		PMP
120	Mori Seiki	1 pcs	12/14/17	12/14/17	0.00	1.72	Mori Seiki TL-40		PMP
130	QC	1 pcs	12/14/17	12/14/17	0.00	0.00	QC2-1		PMP
140	QC	1 pcs	12/14/17	12/14/17	0.00	0.00	QC8		DASMP
145	Crosstubes	1 pcs	12/14/17	12/14/17	0.00	0.45	Crosstubes-1		47
150	HandFXtube	1 pcs	12/15/17	12/15/17	0.00	0.33	Crosstubes-3		9-89 GP
160	QC	1 pcs	12/15/17	12/15/17	0.00	0.00	QC7-1		18-03-01 SA
170	Packaging	1 pcs	12/15/17	12/15/17	0.00	0.00	Packaging3-1		DAS
180	QC21-FG	1 Ea	12/15/17	12/15/17	0.00	0.00	QC21		DPL

Part Op 100 - 1-Fill tube with sand & install plugs on both ends as per Folio FB298 2-Turn first side as per Folio FB298

Descriptions: 120 - 1-Turn second side as per Folio FB298

145 - GRIND ONLY TRANSITION LINES SMOOTH LONGITUDE WAY.

150 - 1- handfinish X-TUBE INSIDE AND OUT

170 - LOCATION : LG014

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D6023-106	1	45	0	0

B150 731

Part Specifications

Specifications could not be found.

Plex 12/5/17 2:44 PM Dart.lajeunesse.marie

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



Work Order update only ☐

Dart Aerospace Ltd.
 1270 Aberdeen Street
 Hawkesbury, ON K64 1K7
 CANADA
 TEL.: 1 613 632-5200
 Email: sales@dartaero.com
 www.dartaerospace.com

DART
 AEROSPACE
S024303



Crosstube Turning Detail

D119-796-241TRN

Start up Operation

Mfg Date: 12/18/17
Job No: 169264-A

PART NO:
Revision:
Operation:
Change No:

Tribal Knowledge	☐	Rushing	☐	Crushing	☐
LOA	☐	Product Improvement	☐	Heat Treat	☐
Substation	☐	Process Improvement	☐	Wave/Twist in Tube	☐
Past Expiry Date	☐	Manufacturing Process	☐	Marks/Chatter	☐
Misidentified	☐	Past Due	☐	OTHER :	☐

ITION	AGAINST DEPARTMENT/PROCESS																																																																																																																																	
Rework ☐	Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																																																																																																																														
Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																																																																																																																														
Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																																																																																																																														
Approved ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																																																																																															
QTY Effective :			MRB (QSI042) Approval																																																																																																																															
Disposition																																																																																																																																		
Completed By																																																																																																																																		
Lead hand / Supervisor Approval Verification																																																																																																																																		
QC / QA Coordinator Approval																																																																																																																																		
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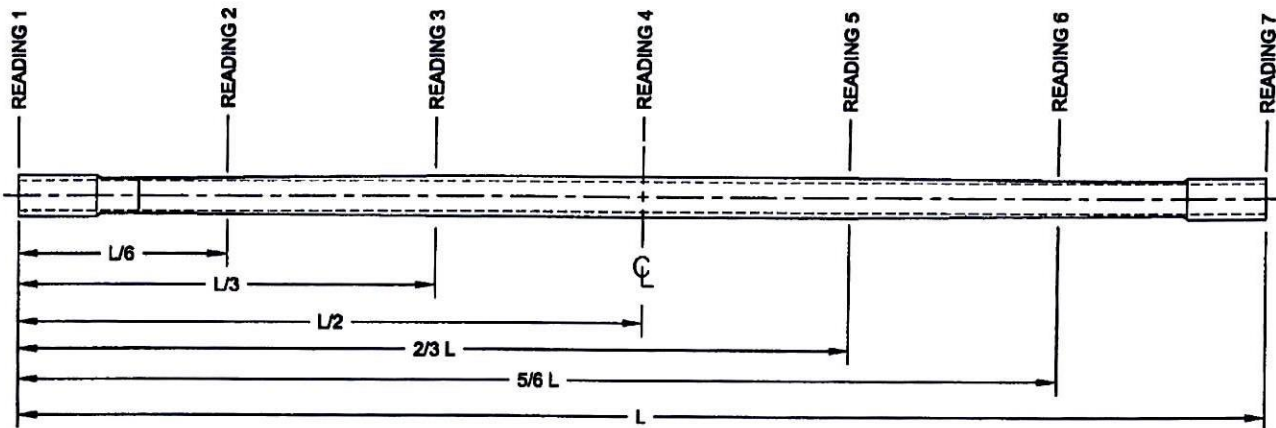
DART AEROSPACE LTD		Work Order:	169264-A
Description: Crosstube Assembly (AW119 MKII Aft)		Part Number:	D119-796-241TRN
Inspection Dwg: D119-796-241 Rev: J		Page 1 of 2	

FIRST ARTICLE INSPECTION CHECKLIST

	Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	5.88	+/-0.030	5.825		✓	VERNO8	
	2.516	+0.005/-0.000	2.520	✓		↓	
	2.626	+0.005/-0.000	2.630	✓			
	2.627	+0.005/-0.000	2.631	✓			
	2.798	+0.005/-0.000	2.802	✓			
	2.799	+0.005/-0.000	2.804	✓			
	2.989	+0.005/-0.000	2.994	✓			
	3.191	+0.005/-0.000	3.196	✓			
	3.200	+0.005/-0.000	3.204	✓			
SIDE B	5.88	+/-0.030	5.830	✓	✓	VERNO8	
	2.516	+0.005/-0.000	2.520	✓		↓	
	2.626	+0.005/-0.000	2.630	✓			
	2.627	+0.005/-0.000	2.631	✓			
	2.798	+0.005/-0.000	2.802	✓			
	2.799	+0.005/-0.000	2.804	✓			
	2.989	+0.005/-0.000	2.994	✓			
	3.191	+0.005/-0.000	3.196	✓			
	3.200	+0.005/-0.000	3.2045	✓			
	105.71	+/-0.020	105.705	✓		TAPE	

DART AEROSPACE LTD	Work Order: 164264-A
Description: Crosstube Assembly (AW119 MKII Aft)	Part Number: D119-796-241TRN
Inspection Dwg: D119-796-241 Rev: J	Page 2 of 2

WALL THICKNESS MEASUREMENT



Location	WALL THICKNESS MEASUREMENT (IN)				Deviation Δw (max-min)	TOLERANCE
	w1	w2	w3	w4		
READING 1 L= 0"	132	137	129	120	.017	0.030"
READING 2 L= 17.62	207	205	197	195	.010	
READING 3 L= 35.24	307	302	300	302	-.007	0.063"
READING 4 L= 52.86	475	481	472	467	-.014	
READING 5 L= 70.47	296	311	312	297	-.016	0.063"
READING 6 L= 88.09	195	194	209	212	.017	0.030"
READING 7 L= 105.71	133	136	125	120	.016	

Calibration Result

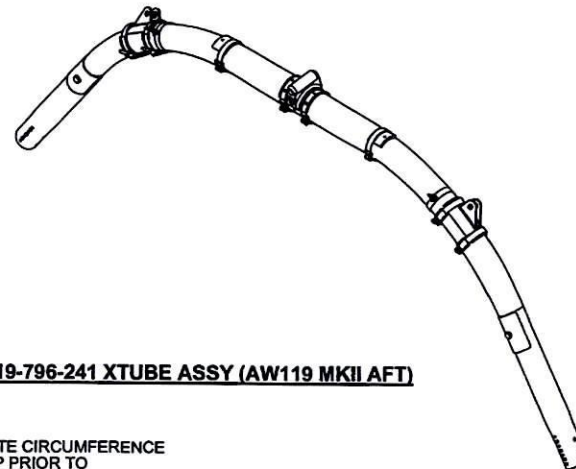
Actual Block Thickness: 100-500

Sitiescan 250 Measured Thickness: 100-500

Measured by: PMP	Audited by: DAS 47 9-89	Preliminary Approval:
Date: 2012-12-18	Date: 12-12-27	Date:

Rev	Date	Change	Revised by	Approved
A	14.09.18	New Issue (P/O D119-796-201)	KJ	
B	15.03.12	Dimensions updated per Dwg Rev F	KJ	
C	15.04.14	Tolerance dimensions revised on Wall Thickness table	KJ	
D	15.05.14	Tolerances revised per Dwg Rev G	KJ	
E	15.09.09	Dwg Rev updated	KJ	
F	16.05.27	Dwg Rev updated	KJ	
G	17.07.12	Dwg Rev updated	KJ	

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WITHOUT NOTICE
WORK ORDER
NO. 169264-A
ML
17-12-05



D119-796-241 XTUBE ASSY (AW119 MKII AFT)

NOTES:

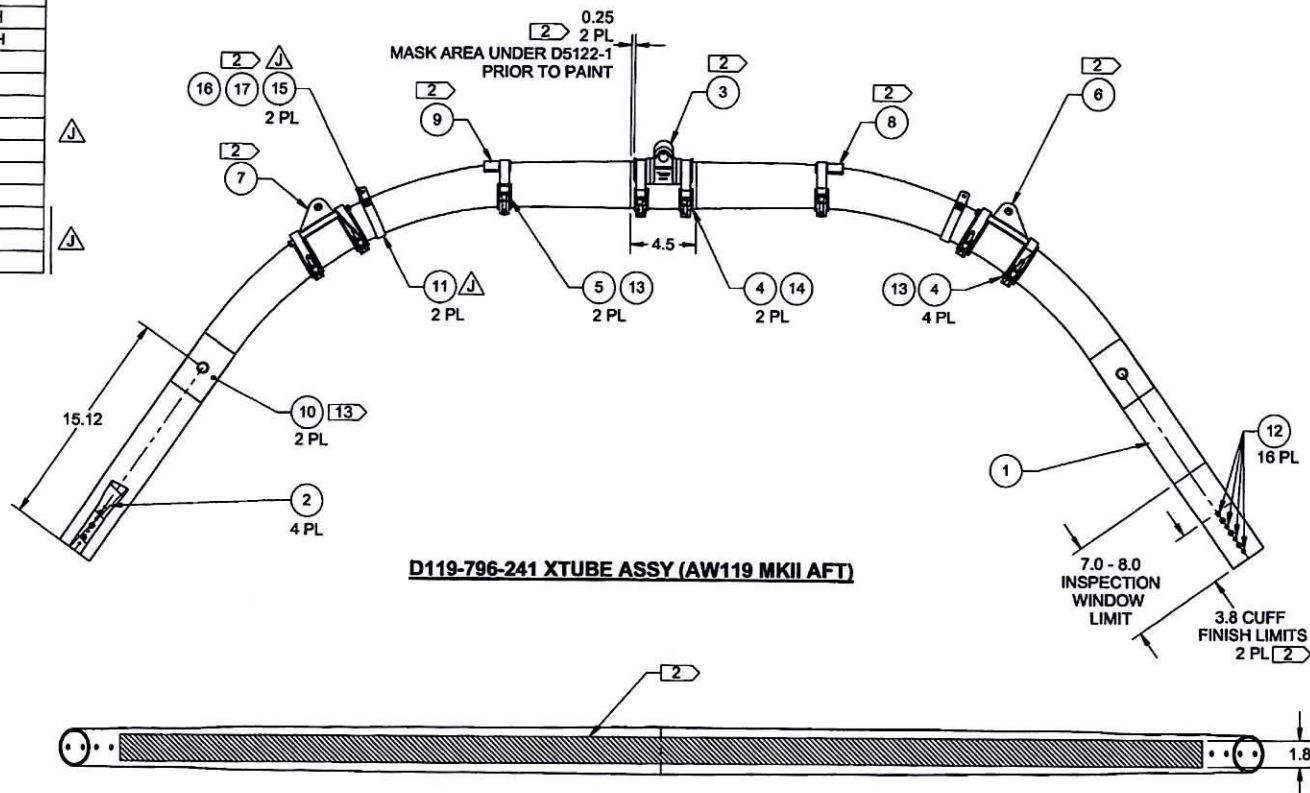
- 1) MATERIAL: N/A
- 2) FINISH: MASK D5134-041/-042 DAMPER SUPPORT ASSEMBLIES, CUFFS, D5136-1/-2 CONTACT PADS, THE COMPLETE CIRCUMFERENCE OF THE TUBE UNDER THE D5122-1 CENTER SUPPORT AND THE TAB ON THE D5515-1 GROUNDING CLAMP PRIOR TO APPLICATION OF CLEAR COAT/PAINT.
IF NECESSARY TOUCH UP PRIMER ON OUTSIDE OF CROSSTUBE PER DART QSI 005 4.2.
APPLY MATTE CLEAR COAT TO THE UNDERSIDE OF CROSSTUBE AS SHOWN (B4-2, HATCHED AREA) PER QSI 005 4.2.
MASK THE UNDERSIDE OF CROSSTUBE AS SHOWN (B4-2, HATCHED AREA).
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY USING PART NUMBER "D119-796-241" AND BATCH NUMBER ON INSIDE OF CUFF PER QSI 044 6.4
- 7) WEIGHT: 26.26 lbs
- 8) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE.
THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM DEFECTS SUCH AS SCRATCHES, NICKS OR DENTS. DEFECTS UP TO 0.005 MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 9) INSTALL D5122-1 CENTER SUPPORT HAND TIGHT ONLY. DO NOT TORQUE. INSTALL RED TAG TO INDICATE "D5122-1 CENTER SUPPORT MUST BE BONDED PER IIN-D119-796 PRIOR TO FLIGHT".
- 10) PRIOR TO FINISHING, ABRASE MATING SURFACES OF D5136-1/-2 AND SURFACE OF CROSSTUBE WITH SCOTCH BRITE 7447 RED AND REMOVE RESIDUE WITH DUPONT 4105S WASH 'N' WIPE DEGREASER. APPLY A 0.100" MIN THK LAYER OF PROSEAL 890 ON THE INSIDE CONCAVE SURFACE OF THE D5136-1/-2 CONTACT PADS AND INSTALL AT AN 8.4" OFFSET FROM THE CROSSTUBE BENDING PLANE. INSTALL MS21920-25 CLAMPS AND D5123-5 CLAMP CUSHIONS WHILE WET. PRIOR TO PACKAGING, RE-CHECK TORQUE ON CLAMPS AFTER PROSEAL 890 SEALANT HAS CURED FOR 72 HOURS.
- 11) TORQUE MS21920 CLAMPS 80 - 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY. THE NUT HAS NOT BOTTOMED-OUT AFTER TORQUING AND THE NUT IS FACING AFT.
- 12) PRIOR TO FINISHING, POSITION AND INSTALL D5134-041/-042 DAMPER SUPPORTS USING JIG DT10085. ABRASE MATING SURFACES OF THE D5134-041/-042 DAMPER SUPPORTS AND CROSSTUBE WITH SCOTCH BRITE 7447 RED AND REMOVE RESIDUE WITH DUPONT 4105S WASH 'N' WIPE DEGREASER. APPLY A 0.100" MIN THK LAYER OF PROSEAL 890 ON THE INSIDE CONCAVE SURFACE OF THE D5134-041/-042. INSTALL MS21920-25 CLAMPS AND D5123-1 CLAMP CUSHIONS WHILE WET. PRIOR TO PACKAGING, RE-CHECK TORQUE ON CLAMPS AFTER PROSEAL 890 SEALANT HAS CURED FOR 72 HOURS. ENSURE THAT THE MS21920 CLAMPS ARE POSITIONED AS SHOWN IN DETAIL C.
- 13) PRIOR TO FINISHING, ABRASE MATING SURFACES OF CROSSTUBE AND D5152-043 WITH SCOTCH BRITE 7447 RED AND REMOVE RESIDUE WITH DUPONT 4105S WASH 'N' WIPE DEGREASER. INSTALL D5152-043 WITH LAYER OF PROSEAL 890 ON INSIDE CONCAVE SURFACE, 0.100" MIN THK LOCATE D5152-043 USING TOOL DT10112.
- 14) INSTALL THE D5515-1 GROUNDING CLAMP AND ASSOCIATED HARDWARE PER DETAIL "C" PRIOR TO FINISHING. TORQUE THE MS21042-3 NUT 12-15 IN-LB. COMPLETELY SEAL THE EDGES OF THE CLAMP USING PROSEAL 890.
- 15) CARRY OUT A RESISTANCE CHECK BETWEEN THE D5515-1 GROUNDING CLAMP AND ANY UNPAINTED SECTION OF THE CROSSTUBE IN ACCORDANCE WITH AC43-13-1B CHAPTER 11. MAXIMUM RESISTANCE IS 3 MILLIOHMS.

RELEASED
2017-05-04
ECN 17-536

J	ADD NOTE 14 & 15 ON SHT 1, ADD PAINT/PRIMER MASKING LOCATIONS, REVISE NOTES ON SHT 1 & 4, REVISE BOM ON SHT 2 TO ADD GROUNDING CLAMP AND ASSOCIATED HARDWARE. REF PAR 17-580	ML	17.02.10
I	D6023-106 MATERIAL REPLACES D6009-106. D5136-1/-2 & D5134-041/-042 NOW INSTALLED ON PRIMER.	AP	15.10.13
H	NOTE 9 RE-WRITTEN. BONDING INSTRUCTIONS MOVED TO IIN. SEE PREVIOUS REV FOR DETAILS.	AP	15.07.02
G	FINISHING ORDER ADJUSTED, UPDATE BEND TOLERANCE AND TRN DETAIL TOLERANCE TO MATCH D119-796-141 DWG	AP	15.04.24
F	REMOVED PRIMER/PAINT ON CUFFS, 2.516 WAS 2.500 (C8-5)	AP	15.02.03
E	D5152-043 WAS D5150-3, SCOTCH BRITE 7447 RED WAS 180 GRIT SANDPAPER	DB	15.01.15
D	ADD D5150-3 STEP POST (2X), MOVED INSPECTION WINDOW DETAIL TO SHT 1, MODIFIED NOTES ON SH 1 & 3	DB	14.11.25
C	CR3212-4-07 RIVETS WAS CR3212-4-05 RIVETS, RADIUS BLOCK WAS NUT PLATE ASSEMBLY (BOM), REMOVED 7.5 DEG CUFF HOLE OFFSET (A1-3), REDUCED CUFF DIA TO 2.500 (C8-5), ADD INSPECTION WINDOW	AP	14.10.23
B	ORIENTATION OF D5122-1 CENTER SUPPORT WAS CORRECTED. D5123-5 ADDED UNDER D5136-1/-2 CONTACT PADS, ADDED D2873-043 NUT PLATE ASSY & CR3212-4-05 RIVETS. ADDED REFERENCE TO SKIDTUBES FOR LOCATING CUFF HOLES. RE-ORGANIZED NOTES, REMOVED REDUNDANT INFORMATION.	AP	14.09.08
A	NEW ISSUE	AP	14.08.07
REV.	DESCRIPTION	BY	DATE
DESIGN	AP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	ML		
CHECKED	JMH	DRAWING NO.	REV. J
MFG. APPR.	DP	D119-796-241	SHEET 1 OF 7
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	XTUBE ASSY (AW119 MKII AFT)	NTS
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APPROVED

ITEM	QTY	P/N	DESCRIPTION
	X	D119-796-241	XTUBE ASSY (AW119 MKII AFT)
1	1	D119-796-241BND	CROSSTUBE, AFT
2	4	D2873-043	RADIUS BLOCK
3	1	D5122-1	CENTER SUPPORT
4	6	D5123-1	CLAMP CUSHION
5	2	D5123-5	CLAMP CUSHION
6	1	D5134-041	DAMPER SUPPORT ASSY, LH
7	1	D5134-042	DAMPER SUPPORT ASSY, RH
8	1	D5136-1	CONTACT PAD, LH
9	1	D5136-2	CONTACT PAD, RH
10	2	D5152-043	AFT POST MOUNT ASSY
11	2	D5515-1	GROUNDING CLAMP
12	16	CR3212-4-07	CSK RIVET, CHERRY MAX
13	6	MS21920-25	CLAMP
14	2	MS21920-28	CLAMP
15	2	MS27039-1-08	SCREW, PAN-HEAD
16	2	MS21042-3	NUT
17	4	NAS1149D0332J	WASHER

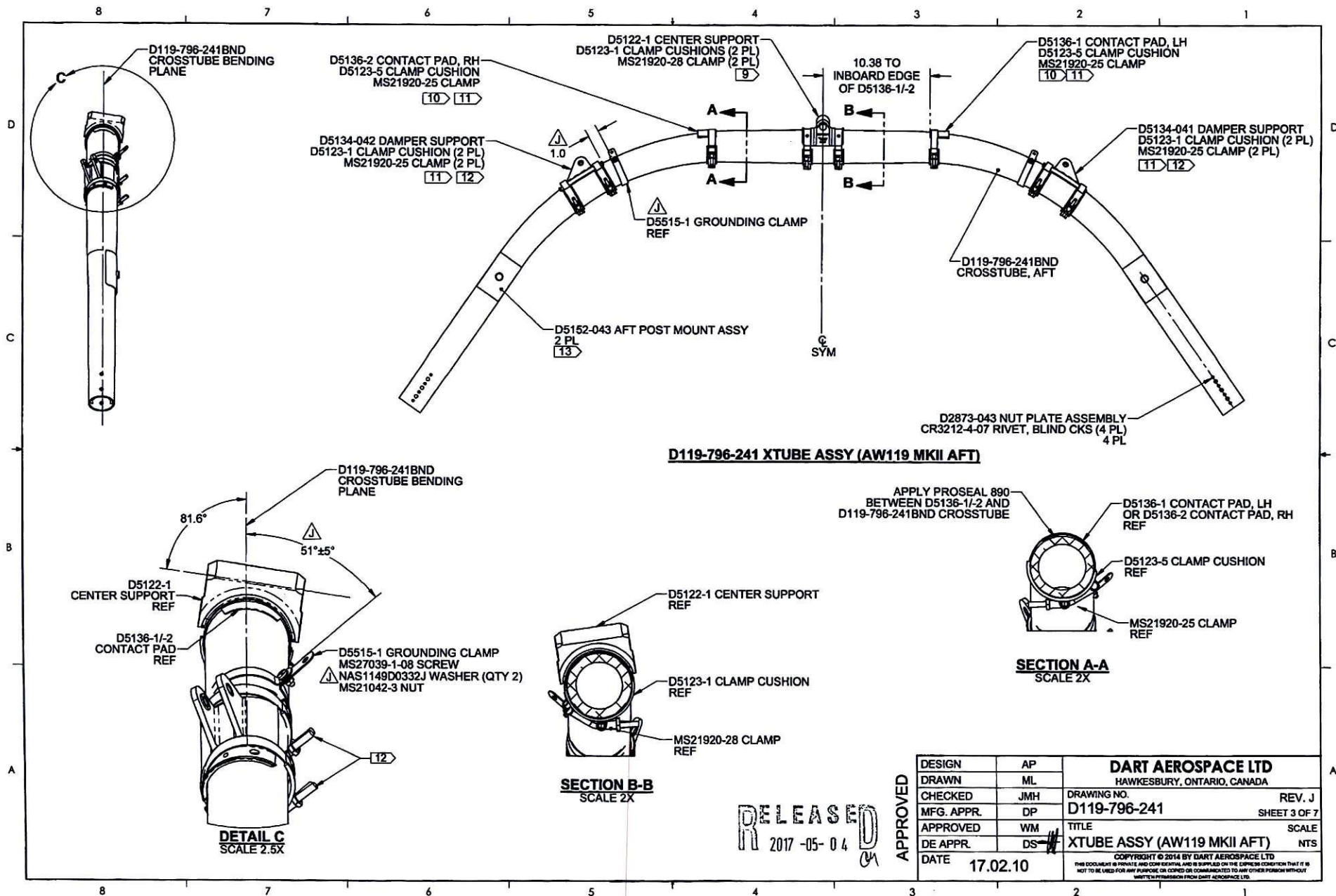


D119-796-241 XTUBE ASSY (AW119 MKII AFT)

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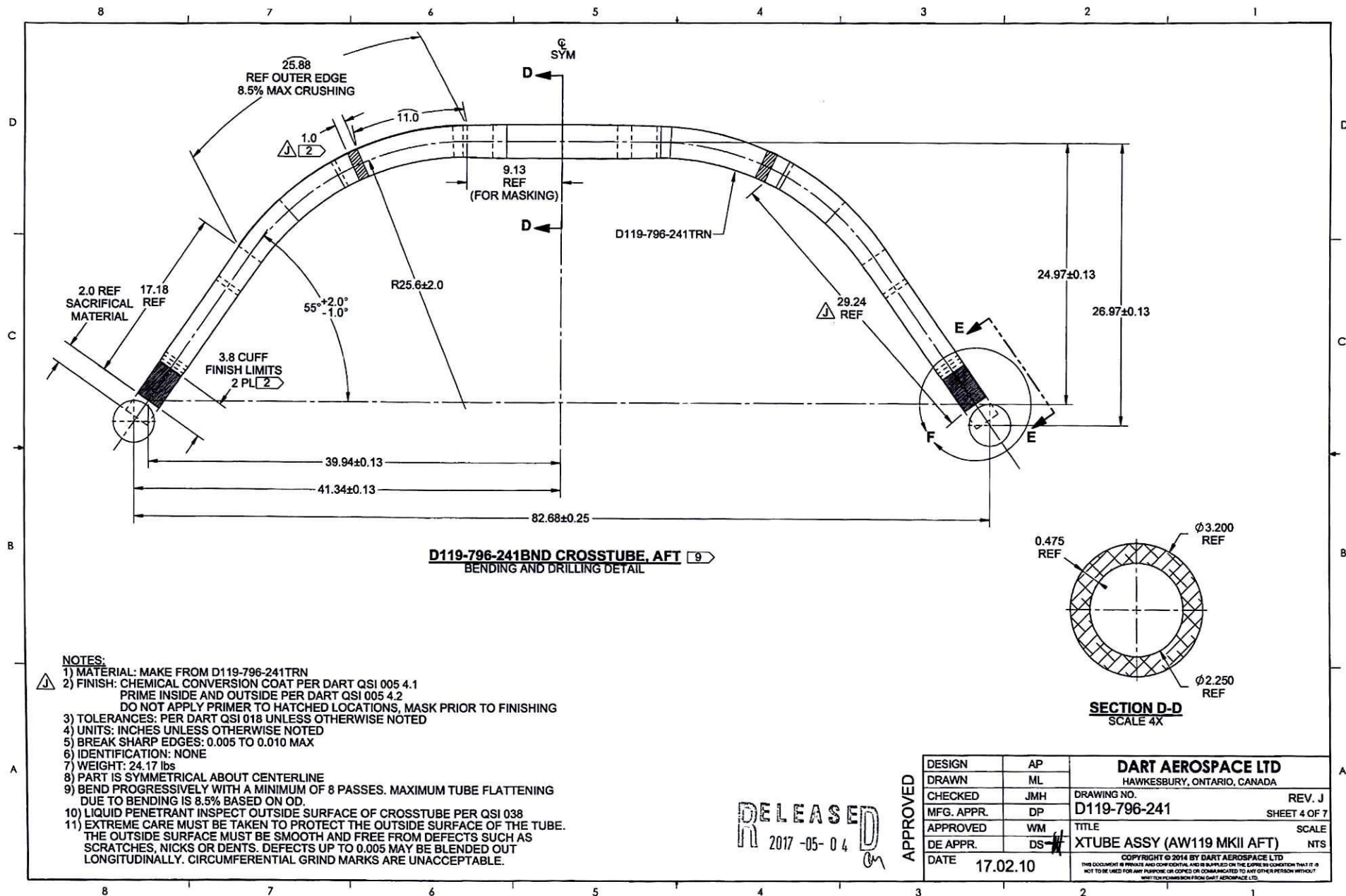
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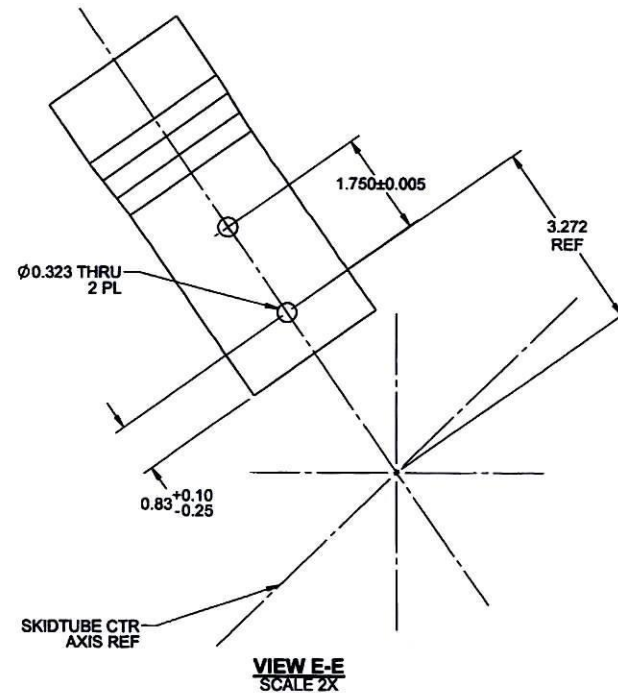
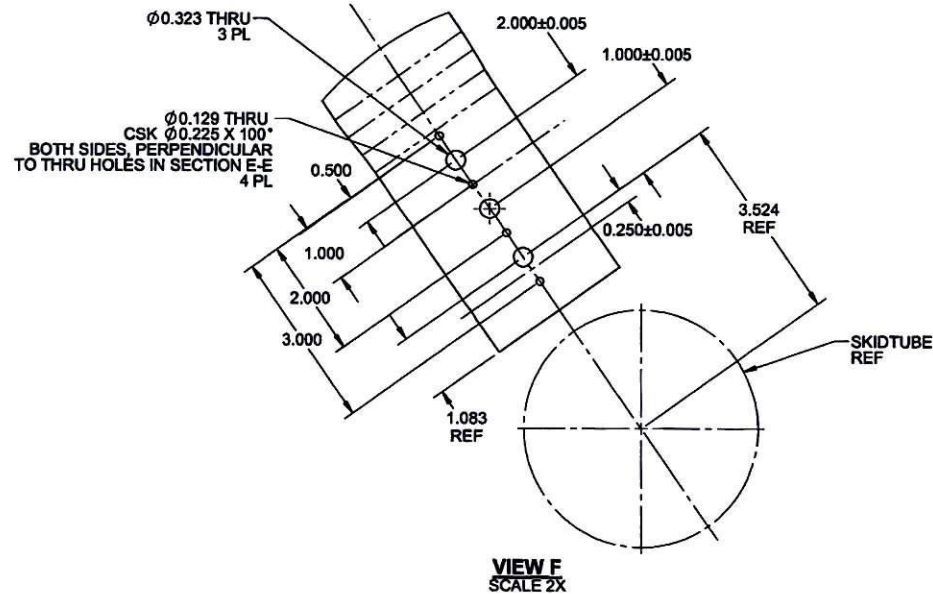
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DRAWN	ML	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JMH	DRAWING NO.	REV. J
MFG. APPR.	DP	D119-796-241	SHEET 2 OF 7
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DE APPR.	DS	XTUBE ASSY (AW119 MKII AFT)	NTS
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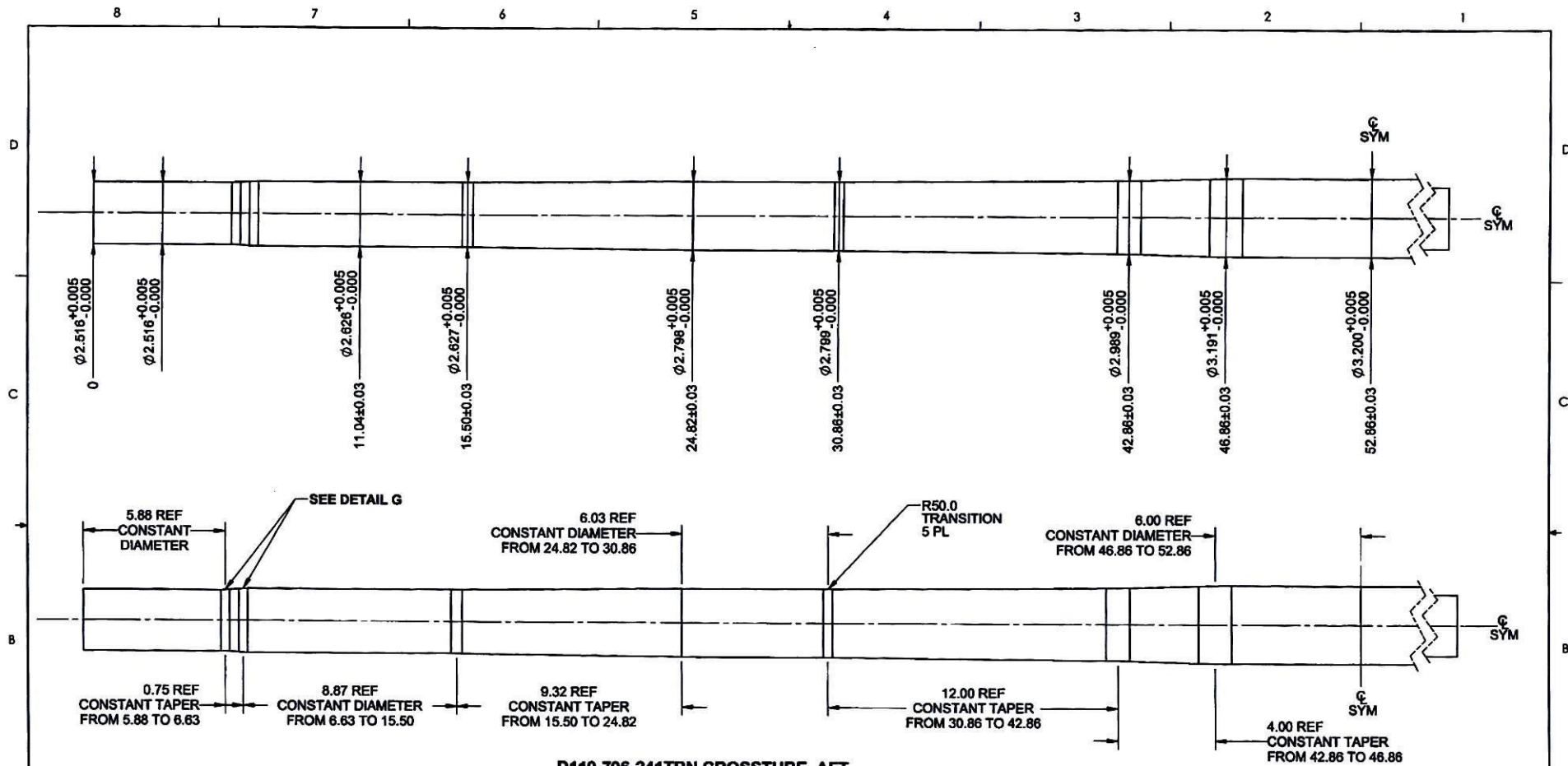




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2017-05-04

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DESIGN	AP	DART AEROSPACE USA, INC.	
DRAWN	ML	KENT, WA	
CHECKED	JMH	DRAWING NO.	REV. J
MFG. APPR.	DP	D119-796-241	SHEET 5 OF 7
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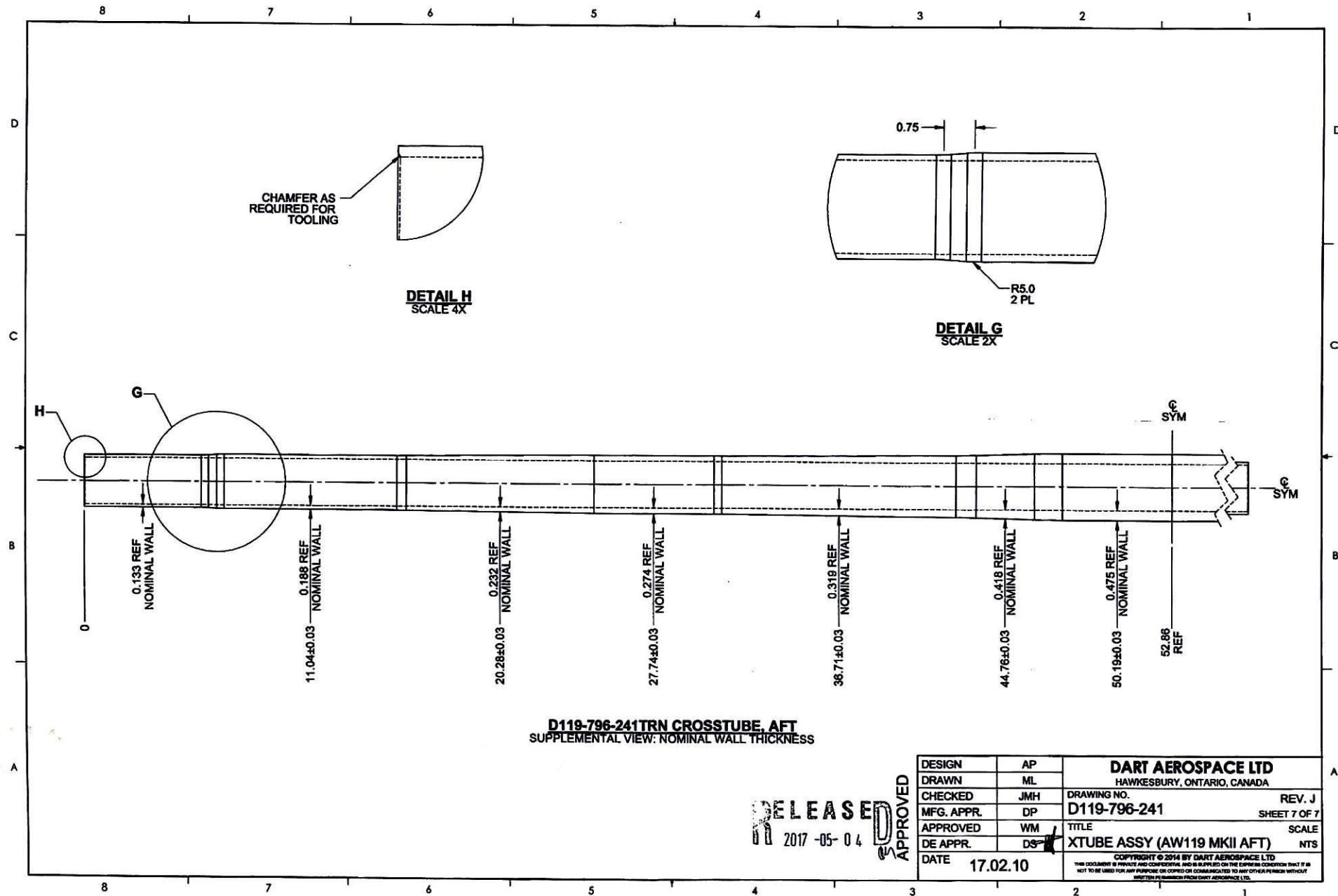
NOTES:

- 1) MATERIAL: MANUFACTURE FROM D6023-106 (PREFERRED) OR D6009-106
FINISHED LENGTH = 105.71 ± 0.020 (BEFORE BENDING/TRIMMING)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 24.17 lbs
- 8) PART IS SYMMETRICAL ABOUT CENTERLINE

RELEASED
2017-05-04

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DESIGN	AP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	ML		
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